

*Tuesday, June 22, 2010 3:22:56 PM*



**Accept**

**Setup Start**

**Stop**

**Cust Item ID:**[illegible]

**Customer:**

**Reference:**

### Process Plan:

Date: 10-6-22T

## 2. Tooling:

**Date:**

Run Start



**QC:**

Date:

**SPC (Y/N):**

Date:

**Stop**

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 60014**

Tuesday, June 22, 2010 3:22:56 PM



Page 2

Item ID: D4042-5

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 6/22/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 7/30/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/24 *[Signature]*PS 10-6-24  
*[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, June 22, 2010 3:23:01 PM

Page 1

Work Order ID: 60014

Parent Item: D4042-5

Parent Item Name: Rib



Start Date: 6/22/2010

Required Date: 7/30/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 10.01.07 verified by:EC IPP Rev:B as per dwg  
revA DD 10.02.18 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304TS0.750W.049

Purchased

No

100

f

446.7945

5.333

5.613684



304 SQ Tube .75x.75x.049W



SAD

10-06-23

Location

Loc Qty

Loc Code

MAT

146.7944919

113763

0

114323

28.3020789

114677

14.34201

114835

104.150403

5.613684

MAT017

3.68448E-05

114298

3.6845E-05

WA

300

114992

300

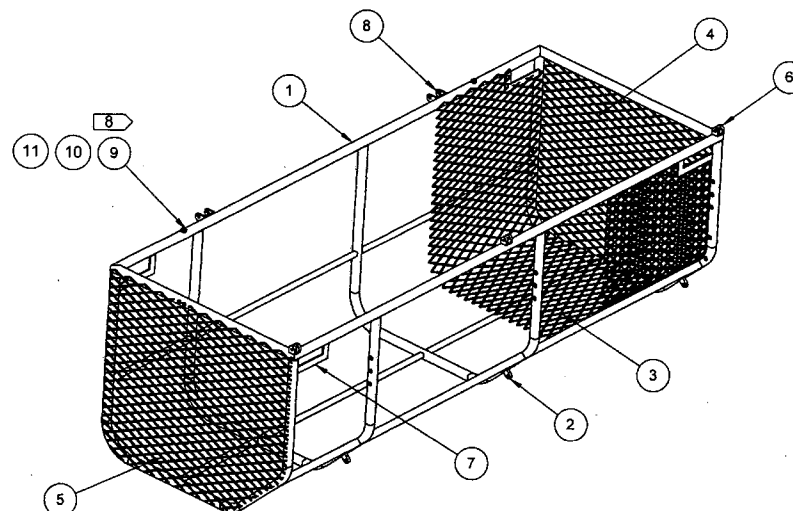
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4042-041 SHORT BASKET ASSY, LH**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 28.82 lbs APROX
- 8) INSTALL AFTER FINISH
- 9) TRIM LOCALLY AS REQUIRED TO CLEAR FASTENERS/STRUCTURE
- 10) WELD PER DART QSI 004

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4042-041	SHORT BASKET BASE ASSY, LH
1	1	D4042-101	BASKET BASE FRAME ASSY, LH
2	3	D4045-1	LUG
3	1	D4046-1	MESH BASKET BASE
4	1	D4046-3	MESH FWD END
5	1	D4046-5	MESH AFT END
6	3	D4016-1	HINGE HALF, BASE
7	4	D4021-1	HANDLE PLATE
8	2	D2581	MOUNTING BRACKET
9	2	D2931	BUMPER
10	2	AN960JD8	WASHER
11	2	MS20600AD4W3	RIVET

SHOP  
REWORK  
UNCONTROLLED  
SUBJECT TO AMEND  
WITHOUT NOTICE  
WORK ORDER  
NO. 60014  
*BS10-6-22*

**RELEASED**  
2010-02-16  
*MP*

A NEW ISSUE		RF	10.01.29
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>RF</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>RF</i>	D4042	SHEET 1 OF 11
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	SHORT BASKET BASE ASSY	NTS
DATE	10.01.29	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS  NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT  WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

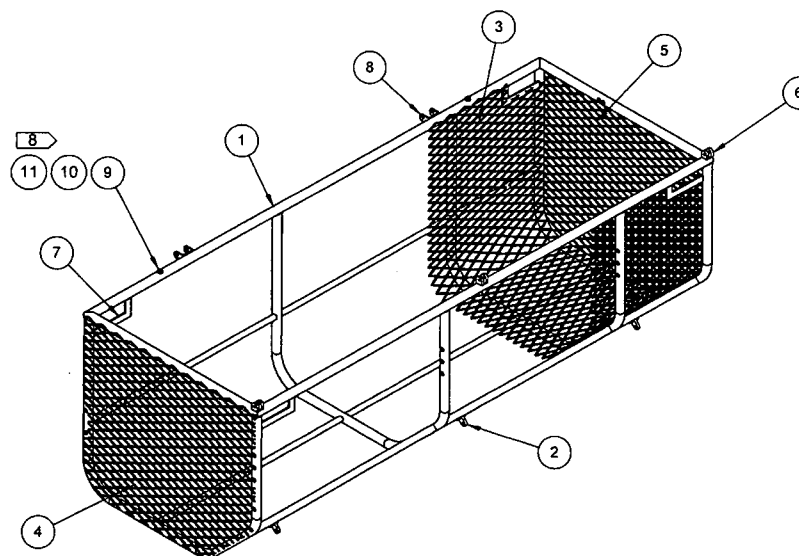
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



ITEM	QTY -042	P/N	DESCRIPTION
	X	D4042-042	SHORT BASKET BASE ASSY, RH
1	1	D4042-102	BASKET BASE FRAME ASSY, RH
2	3	D4045-1	LUG
3	1	D4046-1	MESH BASKET BASE
4	1	D4046-3	MESH FWD END
5	1	D4046-5	MESH AFT END
6	3	D4016-1	HINGE HALF, BASE
7	4	D4021-1	HANDLE PLATE
8	2	D2581	MOUNTING BRACKET
9	2	D2931	BUMPER
10	2	AN960JD8	WASHER
11	2	MS20600AD4W3	RIVET







**D4042-042 SHORT BASKET ASSY, RH**  
(MESH SHOWN LOCALLY FOR CLARITY)

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 28.82 lbs APROX
- 8) INSTALL AFTER FINISH
- 9) TRIM LOCALLY AS REQUIRED TO CLEAR FASTENERS/STRUCTURE
- 10) WELD PER DART QSI 004

**RELEASED**  
2010-02-16  
JMP

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4042	SHEET 2 OF 1
APPROVED		TITLE	SCALE
DE APPR.		SHORT BASKET BASE ASSY	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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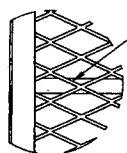
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

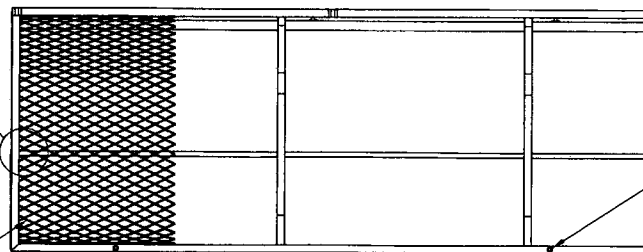


DETAIL A  
SCALE 4X D6-3

TACK WELD MESH  
AT EVERY AVAILABLE  
LOCATION

D4046-1  
MESH

A  
C7-3



8  
D2931 BUMPER  
AN960JD8 WASHER  
MS20600AD4W3 RIVET  
2 PL

D2581  
MOUNTING BRACKET  
2 PL

2X  
2PL

D4016-1  
HINGE HALF, BASE  
3 PL

3 PL

D4046-5  
MESH AFT END

9  
TRIM MESH TO  
CLEAR BUSHING  
Ø0.75

B

B

C4-4

TACK WELD MESH  
AT EVERY AVAILABLE  
LOCATION

0.25  
TYP

9  
TRIM MESH TO  
CLEAR BUSHING  
Ø0.75

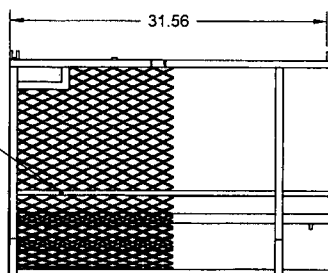
TACK WELD MESH  
AT EVERY AVAILABLE  
LOCATION

A4-4

D4046-3  
MESH FWD END

0.25  
TYP

9



D4042-101

D4042-041 SHORT BASKET ASSY, LH  
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED  
2010-02-16

W/O 60014

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4042	REV. A
MFG. APPR.	RF	TITLE	SHEET 3 OF 11
APPROVED	RF	SHORT BASKET BASE ASSY	SCALE NTS
DE APPR.	RF	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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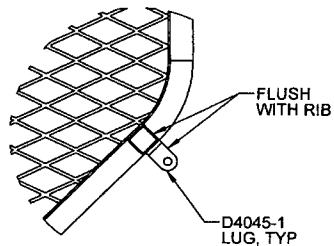
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**SECTION D-D** D6-4  
SCALE 2X, TYPICAL

D4044-5  
AFT RIB  
REF

D4044-043  
CENTER RIB ASSY  
REF

D4044-041  
FWD RIB ASSY  
REF

D4045-1  
LUG, 3 PL

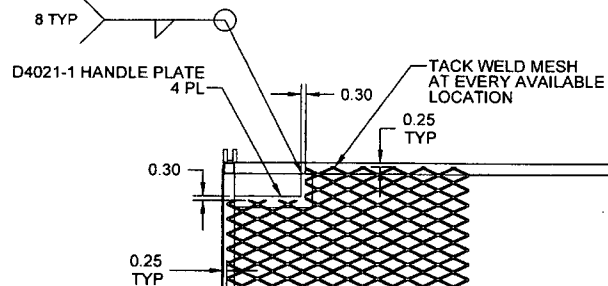
D C7-4

1.96

2.43

2.53




**VIEW B-B** B1-3  
(MESH NOT SHOWN FOR CLARITY)  
SCALE 3:2X



D4046-1  
MESH, REF

**SECTION C-C** C7-3  
SIMILAR OPPOSITE VIEW  
(MESH SHOWN LOCALLY FOR CLARITY)  
SCALE 3:2X

**RELEASED**  
2010-02-16

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4042</b>	SHEET 4 OF 11
APPROVED		TITLE	SCALE
DE APPR.		<b>SHORT BASKET BASE ASSY</b>	NTS
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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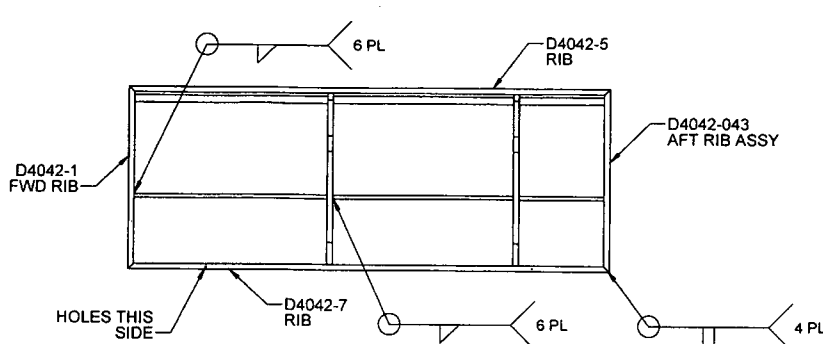
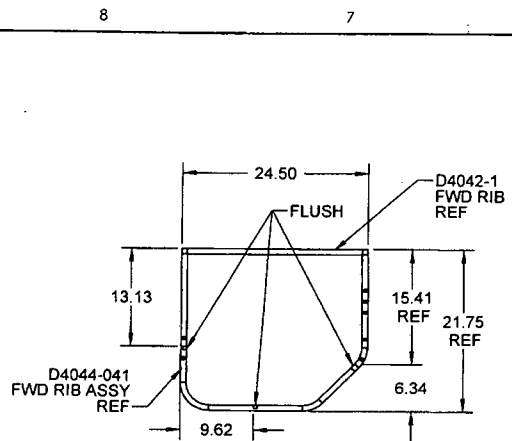
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

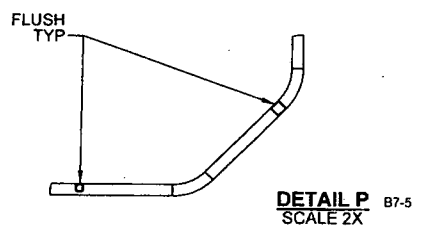
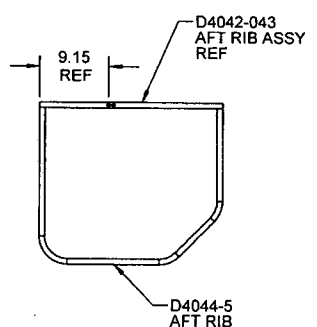
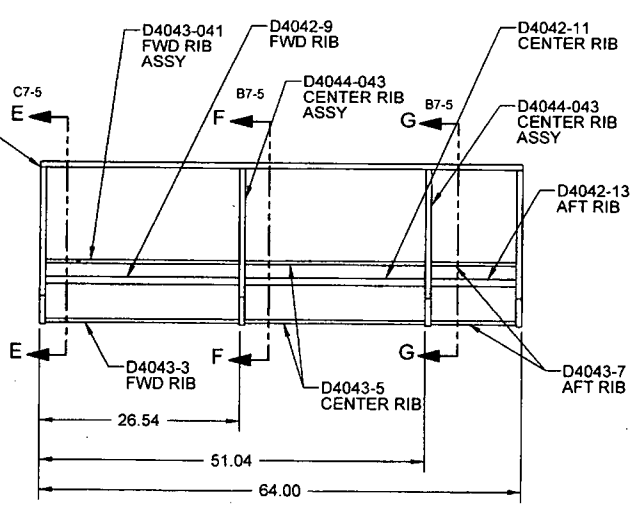
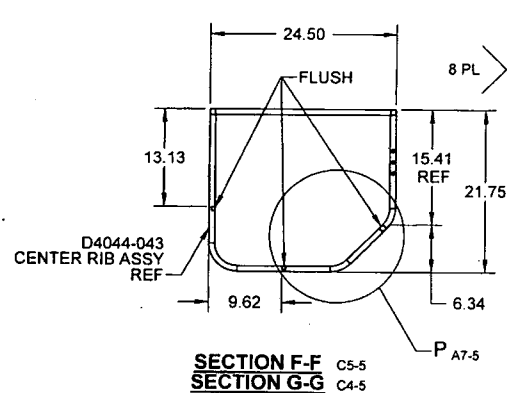
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



QTY -101	P/N	DESCRIPTION
X	D4042-101	BASKET BASE FRAME ASSY, LH
1	D4042-043	AFT RIB ASSY
1	D4043-041	FWD RIB ASSY
1	D4044-041	FWD RIB ASSY
2	D4044-043	CENTER RIB ASSY
1	D4042-1	FWD RIB
1	D4042-5	INBOARD RIB
1	D4042-7	OUTBOARD RIB
1	D4042-9	FWD RIB
1	D4042-11	CENTER RIB
1	D4042-13	AFT RIB
1	D4043-3	RIB
2	D4043-5	RIB
2	D4043-7	RIB
1	D4044-5	AFT RIB



**D4042-101 BASKET BASE FRAME ASSY, LH**

**RELEASED**  
2010-02-18

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	92	DRAWING NO.	REV. A
MFG. APPR.	18	<b>D4042</b>	SHEET 5 OF 11
APPROVED	14	TITLE	SCALE
DE APPR.	11	<b>SHORT BASKET BASE ASSY</b>	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

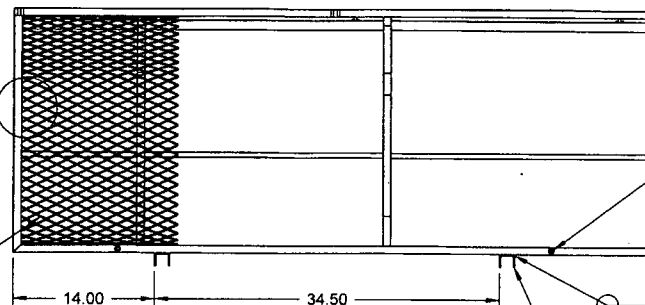


TACK WELD MESH  
AT EVERY AVAILABLE  
LOCATION

DETAIL H D6-6  
SCALE 4X

H  
D7-6

D4046-1  
MESH



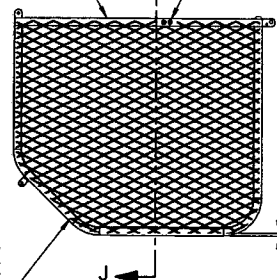
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D2931 BUMPER  
AN960JD8 WASHER  
MS20600AD4W3 RIVET  
2 PL

D2581  
MOUNTING BRACKET  
2 PL

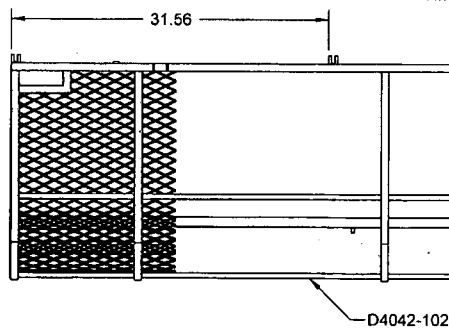
2X  
2PL

9  
D4046-5  
MESH AFT END  
A4-7  
J  
TRIM MESH TO  
CLEAR BUSHING  
Ø0.75

TACK WELD MESH  
AT EVERY AVAILABLE  
LOCATION



0.25  
TYP



D4016-1  
HINGE HALF, BASE  
3 PL

3 PL

D4046-3  
MESH FWD END

0.25  
TYP

C4-7

9  
TRIM MESH TO  
CLEAR BUSHING  
Ø0.75

**D4042-042 SHORT BASKET ASSY, RH**  
(MESH SHOWN LOCALLY FOR CLARITY)

**RELEASED**  
2010-02-16

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV.
MFG. APPR.	RF	D4042	SHEET 6 OF
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	SHORT BASKET BASE ASSY	NT
DATE	10.01.29	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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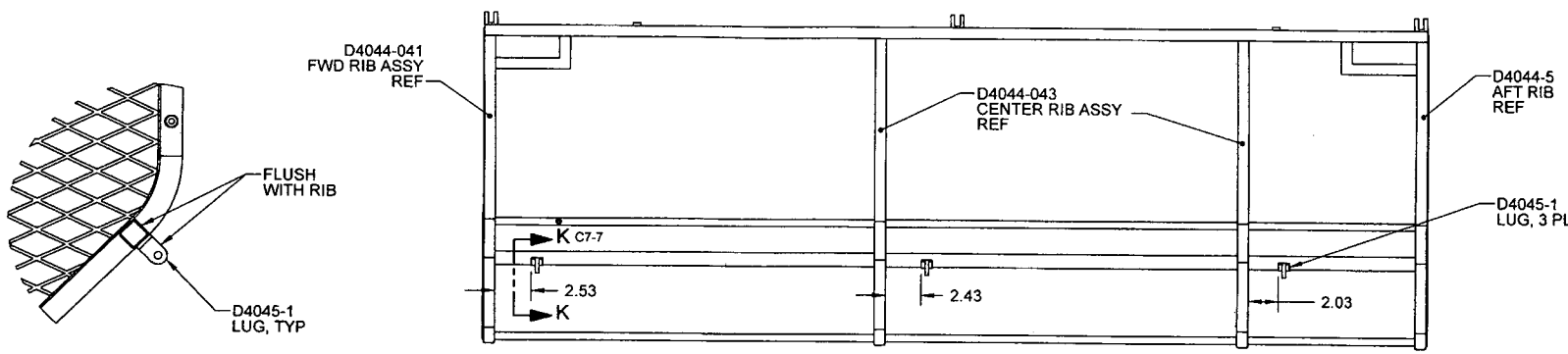
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

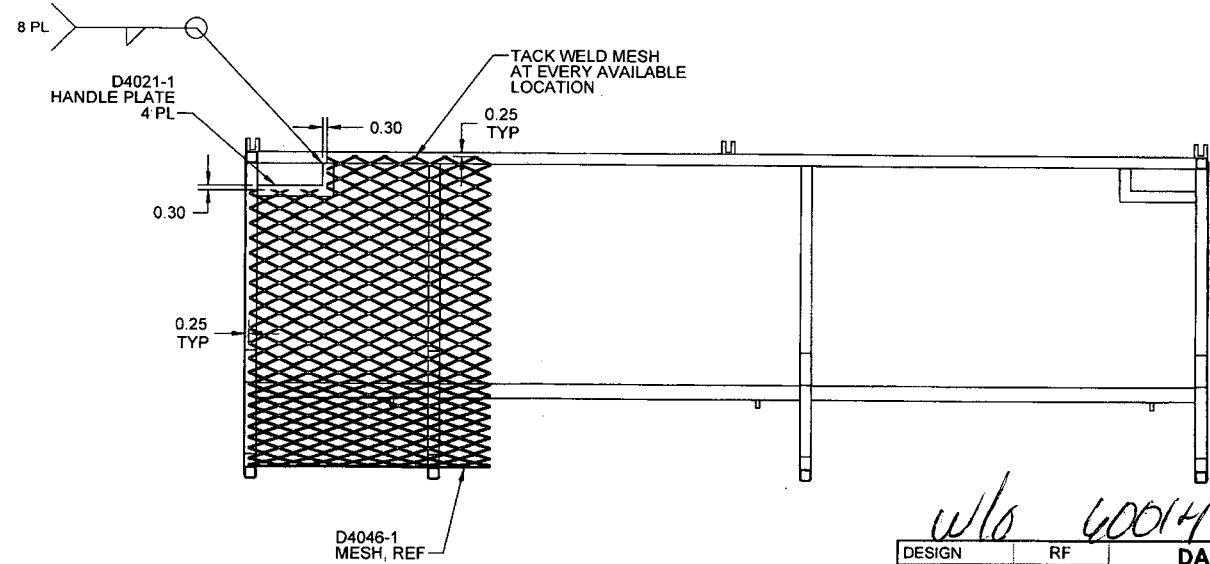
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**SECTION K-K**  
SCALE 2X, TYPICAL D6-7

**VIEW I-I**  
(MESH NOT SHOWN FOR CLARITY)  
SCALE 2:3X C7-6



**SECTION J-J**  
SIMILAR OPPOSITE VIEW  
(MESH SHOWN LOCALLY FOR CLARITY)  
SCALE 3:2X C7-6

**RELEASED**  
2010-02-16  
NAB

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	<b>D4042</b>	SHEET 7 OF 11
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	<b>SHORT BASKET BASE ASSY</b>	NTS
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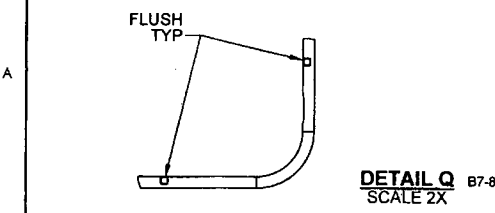
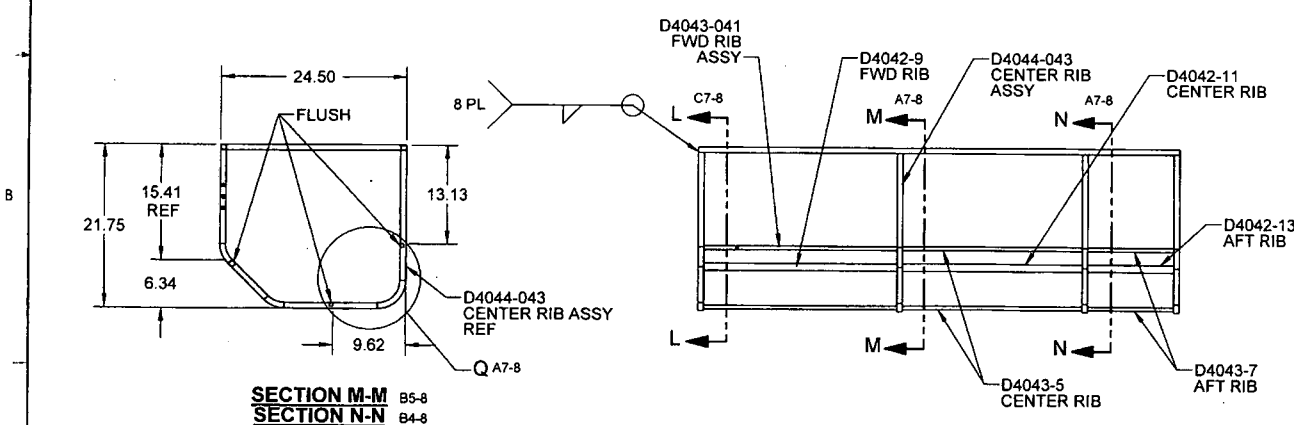
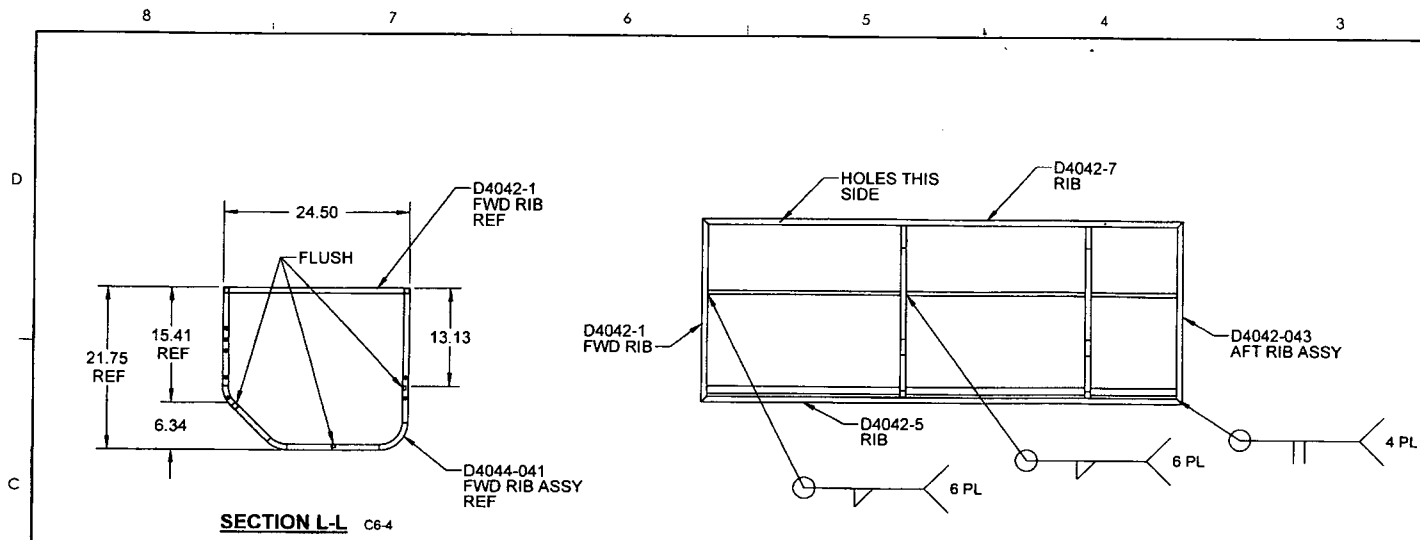
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

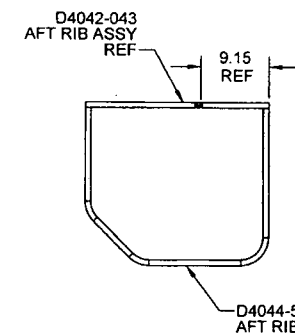
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4042-102 BASKET BASE FRAME ASSY, RH**

QTY -102	P/N	DESCRIPTION
X	D4042-102	BASKET BASE FRAME ASSY, RH
1	D4042-043	AFT RIB ASSY
1	D4043-041	FWD RIB ASSY
1	D4044-041	FWD RIB ASSY
2	D4044-043	CENTER RIB ASSY
1	D4042-1	FWD RIB
1	D4042-5	INBOARD RIB
1	D4042-7	OUTBOARD RIB
1	D4042-9	FWD RIB
1	D4042-11	CENTER RIB
1	D4042-13	AFT RIB
1	D4043-3	RIB
2	D4043-5	RIB
2	D4043-7	RIB
1	D4044-5	AFT RIB



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DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. A
MFG. APPR.	RF	<b>D4042</b>	SHEET 8 OF 11
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	<b>SHORT BASKET BASE ASSY</b>	NTS
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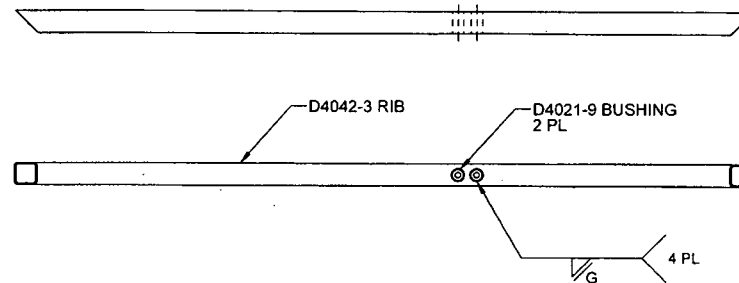
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**NOTE:** Date & initial all entries

ITEM	QTY -043	P/N	DESCRIPTION
	X	D4042-043	RIB AFT ASSEMBLY
1	1	D4042-3	AFT RIB
2	2	D4021-9	BUSHING



**D4042-043 AFT RIB ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.91 lbs
- 8) WELD PER DART QSI 004

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MFG. APPR.	RF	<b>D4042</b>	SHEET 9 OF 11
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**Dart Aerospace Ltd**

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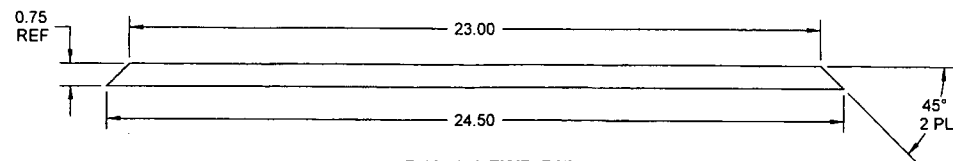
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

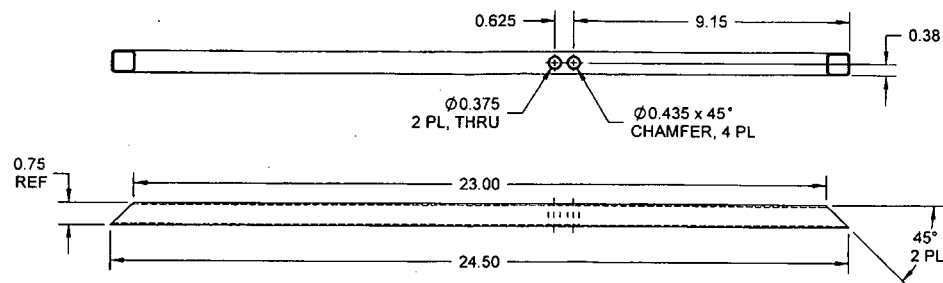
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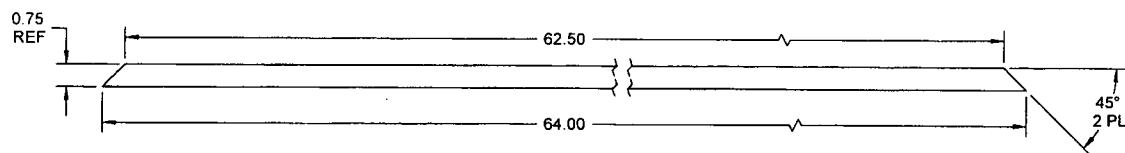




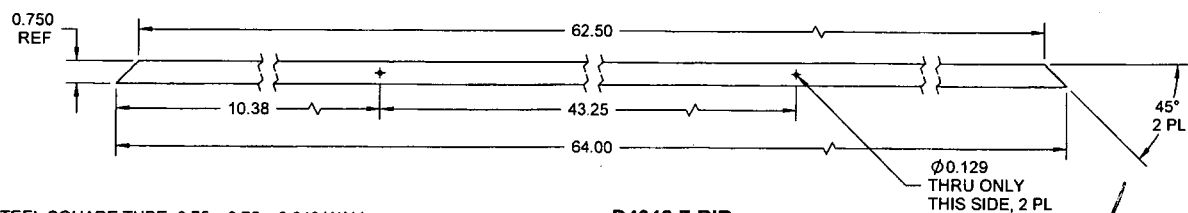
**D4042-1 FWD RIB**



**D4042-3 AFT RIB**



**D4042-5 RIB**



**D4042-7 RIB**

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 x 0.75 x 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4042-1: 0.89 lbs  
D4042-3: 0.88 lbs  
D4042-5: 2.36 lbs  
D4042-7: 2.36 lbs

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MFG. APPR.	RF	<b>D4042</b>	SHEET 10 OF 11
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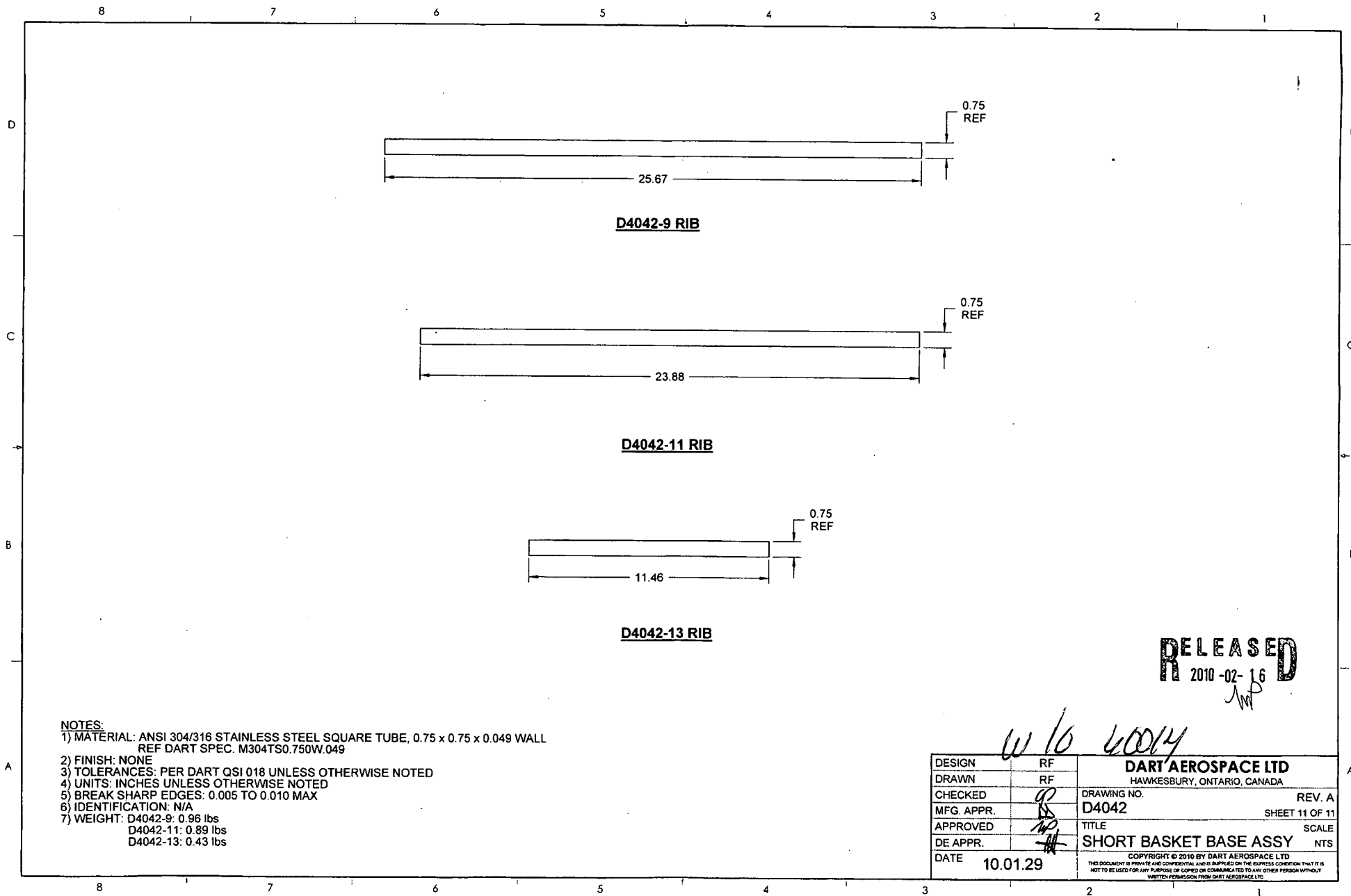
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